

1 **52052/MEG/R541**

WHAT IS CLAIMED IS:

5 1. A footwear comprising:
 a sole including an outsole and insole;
 an upper member affixed to the sole;
 wherein said footwear is floatable in water.

10 2. A footwear of claim 1, wherein the insole is
 constructed of marine buoy material.

 3. A footwear of claim 1, wherein the insole has an
 inner structure and an outer coating, the inner structure
15 being constructed of a thermoplastic resin and the outer
 coating being constructed of a vinyl polymer.

 4. A footwear of claim 1, wherein the upper member is
 constructed of marine buoy material.

20 5. A footwear of claim 2, wherein the marine buoy
 material combination comprises an inner compressible structure
 and a vinyl coating.

25 6. A footwear of claim 1 wherein said footwear is
 substantially water-proof.

 7. A footwear of claim 1, wherein the insole has an
 inner compressible structure and an outer flexible coating.

30 8. A footwear of claim 1, wherein said upper members
 are detachably attached to each other.

 9. A footwear of claim 1 wherein said outsole includes
35 a peripheral border extending upwardly and around said insole.

10. A method for producing a footwear with an insole, an outsole and upper members, comprising the steps of:

5 providing the outsole;
 forming the insole by configuring an inner structure from a thermoplastic resin;
 immersing the inner structure in a vinyl polymer;
 arranging the upper members relative to the insole and
10 the outsole;
 securely affixing the insole, the outsole and the upper members to each other.

11. A method according to claim 10, wherein the step of
15 forming the insole further comprises:
 providing apertures in the inner structure.

12. A method according to claim 10, further comprising:
 forming a strap of the upper members by configuring a
20 strap inner structure from a thermoplastic resin;
 immersing the strap inner structure in a vinyl polymer.

13. A method according to claim 10, wherein the step of
providing the outsole further comprises:
25 forming an outer peripheral border.

14. A method according to claim 10, further comprising:
 adding a color pigment in said vinyl polymer.

15. A method according to claim 14, further comprising:
30 changing the color pigment in said vinyl polymer.

16. A method according to claim 14, wherein said thermoplastic resin composition comprises nature polybutadine
35

1 **52052/MEG/R541**

rubber, polyvinyl chloride past resin, filler talc, foaming agent, plasticizer and process oil.

5 17. A method according to claim 14, wherein said vinyl polymer includes a color pigment selected in accordance with a color of the upper members.

10 18. A method for producing a footwear with an insole, an outsole and upper members, comprising of:

providing the outsole;

forming the insole by configuring an inner compressible structure to have a top surface, a bottom surface and a side surface extending around the perimeter of the inner structure between the top and bottom surfaces;

15 immersing the inner structure in a vinyl polymer to form an outer coating that is a water barrier;

arranging the upper members relative to the insole and the outsole;

20 securely affixing the insole, the outsole and the upper members to each other.

25 19. The method of claim 18, wherein the inner compressible structure is a different material than the outer coating.

30 20. The method of claim 19, wherein the inner compressible structure is a thermoplastic resin.

21. The method of claim 19, wherein the inner compressible structure is a thermoplastic resin that compresses to cushion a foot of a wearer.

35 22. The method of claim 19, wherein the inner

1 **52052/MEG/R541**

compressible structure is a thermoplastic resin that
compresses to generally conform to a shape of a foot of a
5 wearer.

23. The method of claim 18, wherein the inner
compressible structure has a low density relative to the
outsole.

10 24. The method of claim 18, wherein the inner
compressible structure is a single layer of compressible
material and the outer coating contacts the top and side
surfaces of the compressible structure.

15 25. The method of claim 18, wherein the footwear is
buoyant.

26. The method of claim 18, wherein the outsole is wear
20 resistant relative to the insole.

27. The method of claim 18, wherein the inner
compressible structure is compressible compared to the
outsole.

25 28. The method of claim 20, wherein the thermoplastic
resin contains plasticizer.

29. The method of claim 18 wherein immersing forms a
30 seamless continuous layer that substantially covers the entire
top, bottom and side surfaces of the compressible structure.

35